

Date: Monday, 28/08/2006 2:19:57 PM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D2521 / K10015
Job Number	: 28148		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: K10015
This Issue	: 28/08/2006 S.O. No. : N/A	Drawing Number	: Z_CUSTOM
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 10/08/2006 Type : N/A	Drawing Revision	: N/A
Previous Run	: 00015	Material	: N/A
Written By	:	Due Date	: 17/08/2006
Checked & Approved By	:	Qty:	1 Um: Each
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	HAAS1	HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
CUT BLANK PER FOLIO FA222 (19.50 X 48.00" - 2 PER KIT)
MACHINE PER FOLIO FA222 & DRWG D2521 REV.J

see attached

u

2.0	MUHMWB10	UHMW 1" Black
-----	----------	---------------



Comment: Qty.: 13.0000 sf(s)/Unit Total : 13.0000 sf(s)
UHMW 1" Black

1010254

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

see attached

u

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
PICK KIT:
2 X D2521 B 28148 (REF)

Date: Monday, 28/08/2006 2:19:57 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D2521 / K10015

Job Number: 28148

Part Number: K10015

D205-864-011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2182B

Neoprene Cushion-.750 bl



8X Comment: Qty.: 3.6700 f(s)/Unit Total : 3.6700 f(s)
Neoprene Cushion-.750 bl B28042

7.0

D2274

Radius Block



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)
Radius Block B27581

8.0

D2529

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)
Washer B27876

9.0

D2947

Clamp



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Clamp B28770

10.0

D3544041

CLAMP



Comment: Qty.: 4.0000 (s)/Unit Total : 4.0000 (s)
CLAMP B28352

11.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Bolt M101594

12.0

AN415A

Bolt



CB Comment: Qty.: 10 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Bolt M19185

13.0

AN417A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt M19471

Date: Monday, 28/08/2006 2:19:57 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D2521 / K10015

Job Number: 28148

Part Number: K10015

0205-564-011

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

AN960JD416

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)
Washer M19/85

15.0

MS21042L4

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)
Nut
OR MS21042-4 M19/85

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

PU 6/8/28 (1)
CL 06/08/29 (1)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
PACKAGE PER PPP DRAFT

PU 6/8/28 (1)

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Level 21 inspection 06/08/29 (1)

Job Completion



CL 06/08/29

Date: Thursday, 10/08/2006 11:01:48 AM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D2521 / K10015
Job Number	: 28148		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: Z_CUSTOM
This Issue	: 10/08/2006 S.O. No. :	Drawing Number	: Z_CUSTOM
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type :	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 17/08/2006 Qty: 2 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

ml 06/08/25 2

Job Completion



17101627

17101253

1. *Cut BLANK AS per Folio FA222 BATCH: M101254 ml 06/08/25 2*
2. *MACHINE AS per Folio FA222 & Dwg D2521 Rev 5.*
3. *QC2 ml 06/08/25 2*
4. *QCB Sn 06/08/25 x 2*

19.50 + 48

PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2521	REV. J SHEET 1 OF 3
DATE 06.07.28		TITLE 205 BEARPAW	SCALE NTS
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 46.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE	

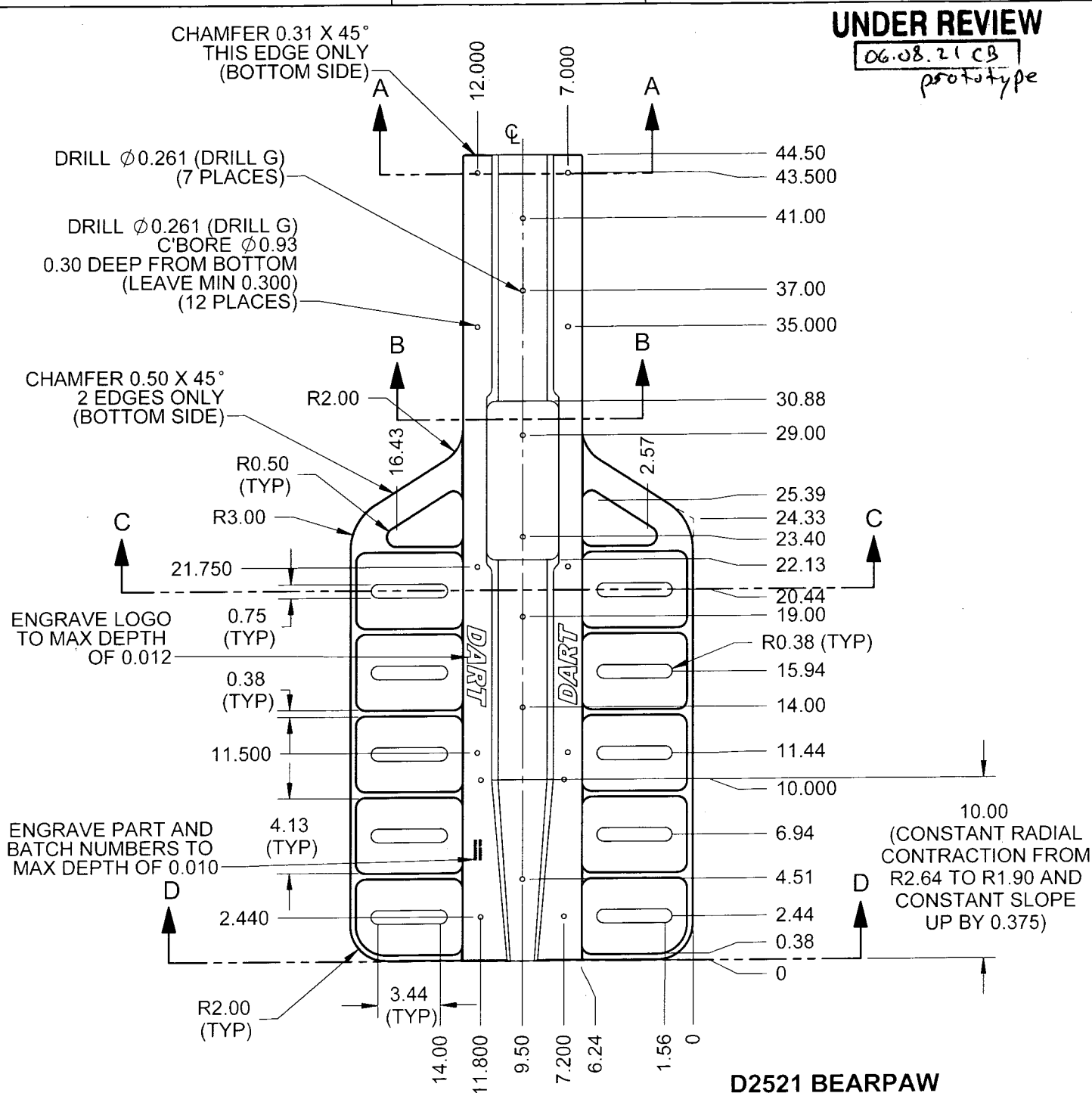
UNDER REVIEW

06.08.21 CB

prototype

PRELIMINARY ISSUE

DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2521	REV. J SHEET 2 OF 3
DATE 06.07.28		TITLE 205 BEARPAW	SCALE 1:8



NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT ϕ

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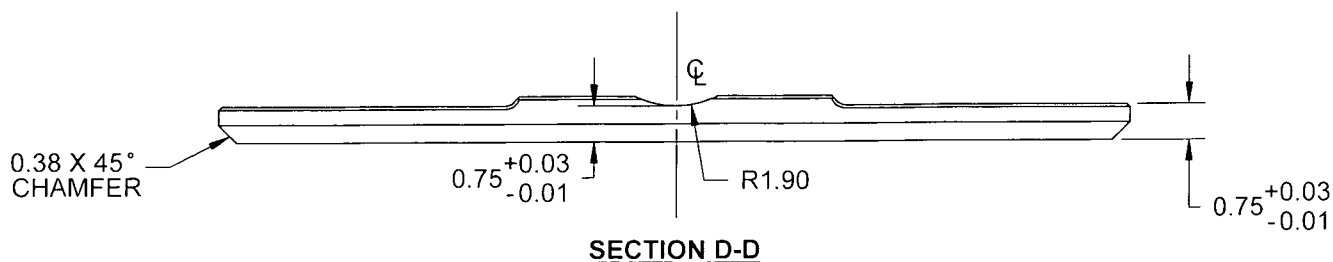
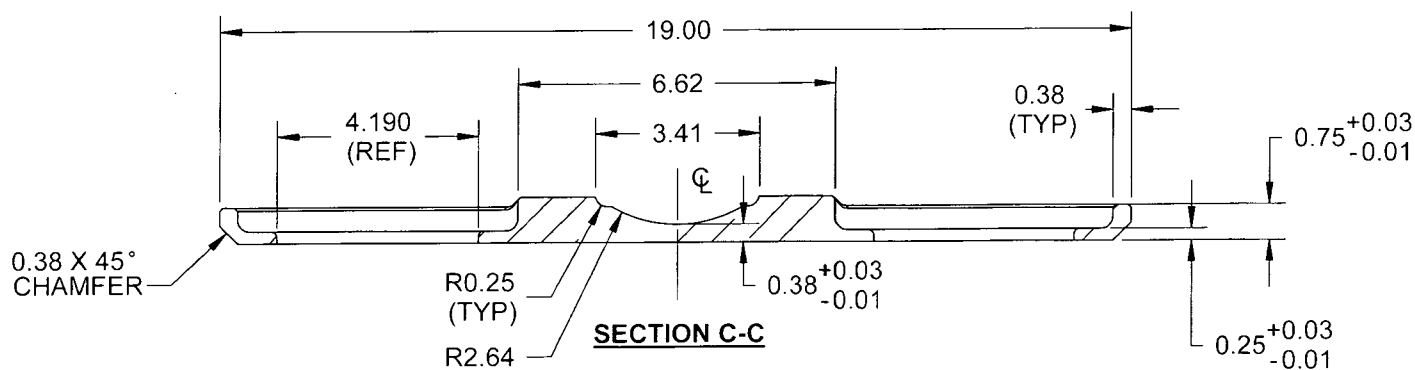
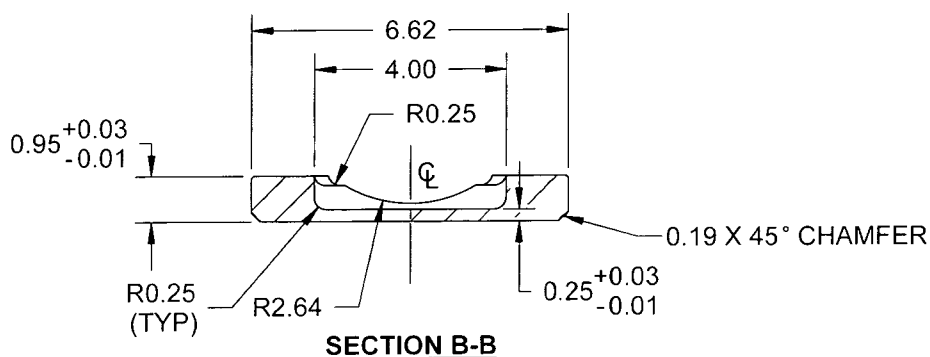
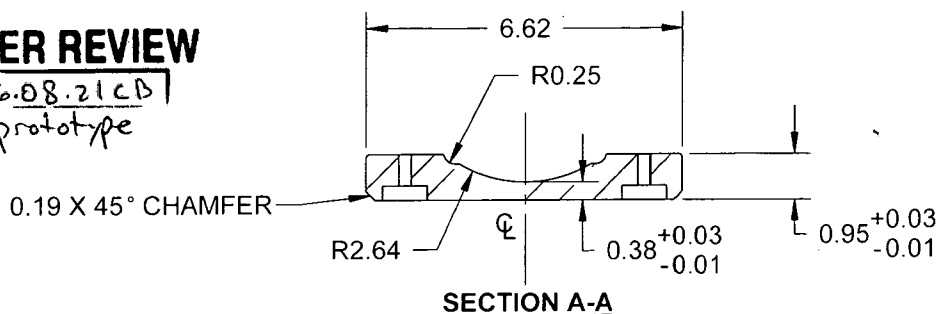
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PRELIMINARY ISSUE

DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2521	REV. J SHEET 3 OF 3
DATE 06.07.28		TITLE 205 BEARPAW	SCALE 1:4

UNDER REVIEW

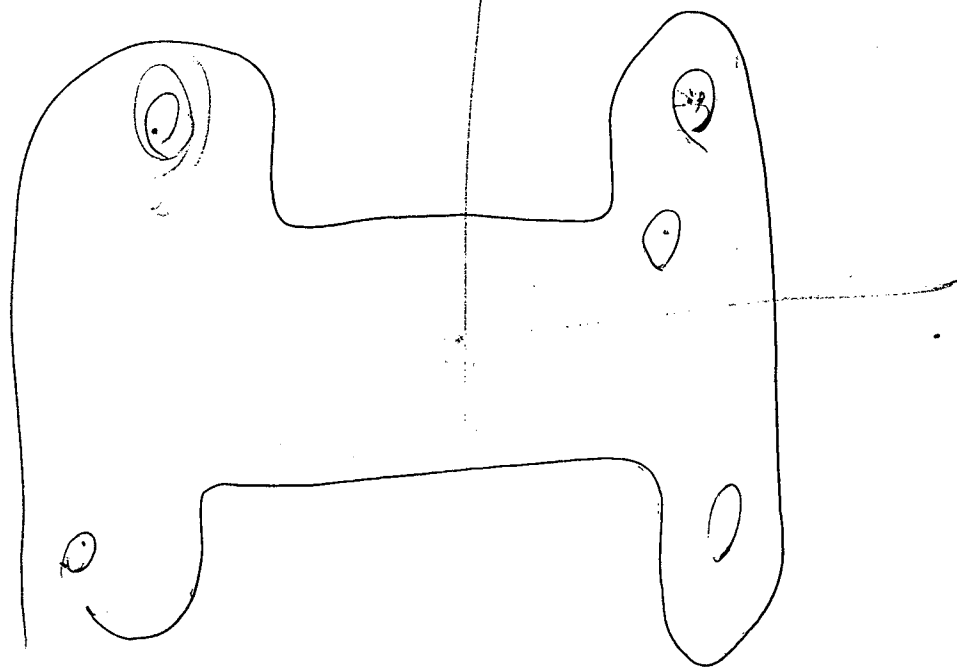
06.08.21 CB
prototype



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0515 20.30



~~Pro Seal~~ →

Sika Flex

[-241]

DART AEROSPACE LTD	Work Order: 28148
Description: 205 BEARPAW	Part Number: D2521
Inspection Dwg: D2521, Rev: J	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	6.62	$\pm .030$	6.628	✓			
B	0.95	$\pm .030$	0.960	✓			
C	0.38	$\pm .030$	0.370	✓			
D	0.19X45°	$\pm .030$	0.193X45°	✓			
E	4.00	$\pm .030$	3.999	✓			
F	0.25	$\pm .030$	0.243	✓			
G	19.00	$\pm .030$	19.000	✓			
H	0.38	$\pm .030$	0.390	✓			
I	0.75	$\pm .030$	0.740	✓			
J	0.25	$\pm .030$	0.245	✓			
K	0.38X45°	$\pm .030$	0.390X45°	✓			
L	3.41	$\pm .030$	3.420	✓			
M	0.75	$\pm .030$	0.747	✓			
N	7.200	$\pm .005$	7.200	✓			
O	11.800	$\pm .005$	11.800	✓			
P	2.440	$\pm .005$	2.440	✓			
Q	21.750	$\pm .005$	21.750	✓			
R	35.000	$\pm .005$	35.000	✓			
S	43.500	$\pm .005$	43.500	✓			
T	44.500	$\pm .005$	44.500	✓			
U	Ø 0.261	$\pm .005$	Ø 0.261	✓			
V	Ø 0.93	$\pm .030$	Ø 0.930	✓			
W	Ø 0.30	$\pm .030$	Ø 0.315	✓			

Measured by: <i>ml</i>	Audited by: <i>MS</i>	Prototype Approval:
Date: 06/08/25	Date: 06/08/25	Date:

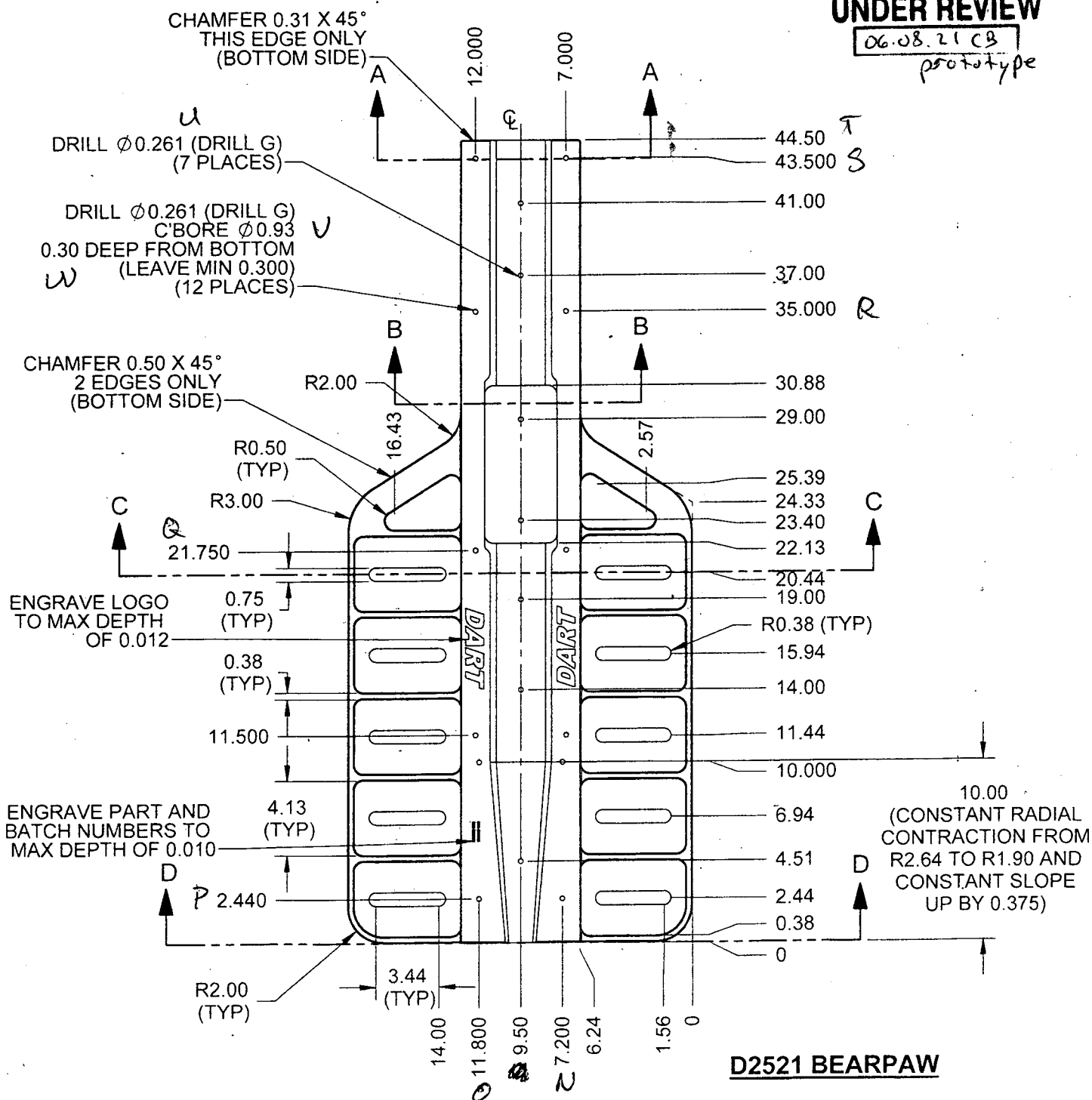
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

PRELIMINARY ISSUE

DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2521	REV. J SHEET 2 OF 3
DATE 06.07.28	TITLE 205 BEARPAW		SCALE 1:8

UNDER REVIEW

06.08.21 *CB*
prototype



NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
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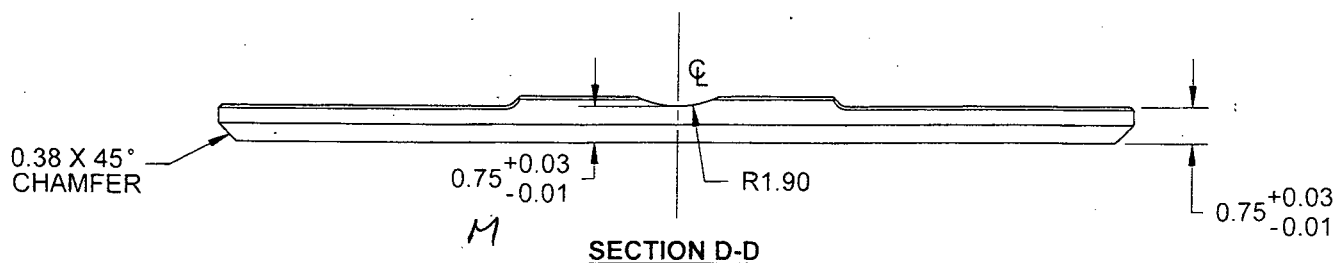
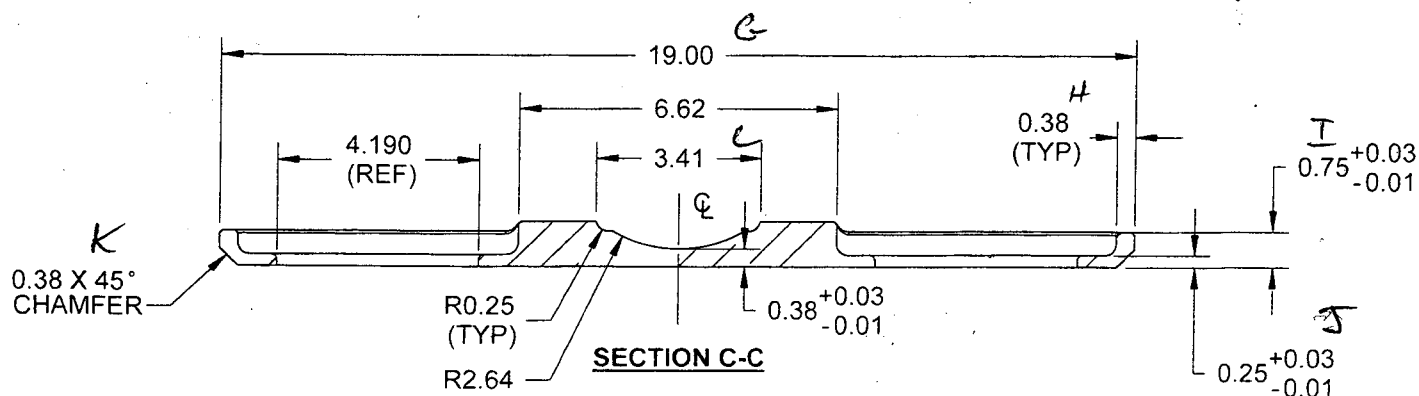
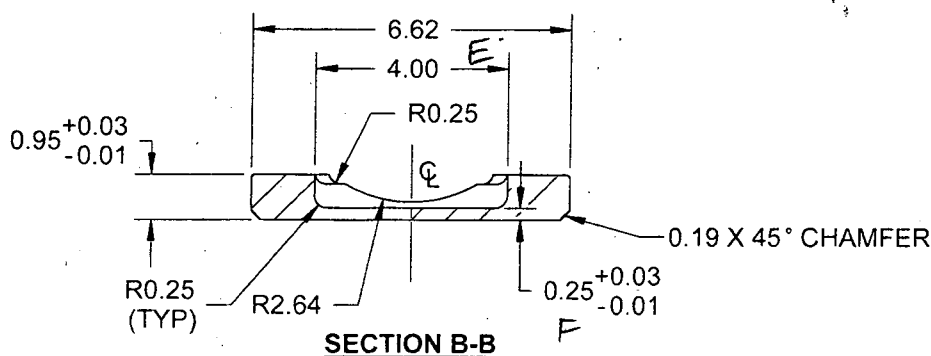
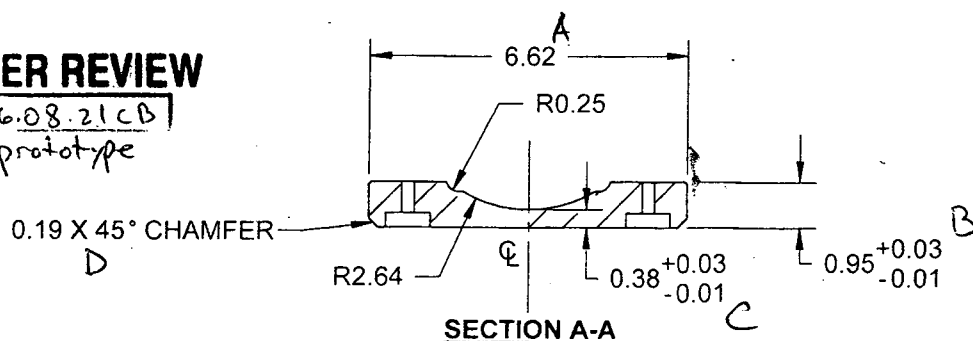
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4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-564-011 (204)	23.0 lb 10.45 kg	0.0 in 0.0 m	0.0 lb-in 0.0 m-kg	159.5 in 4.05 m	3668.5 in-lb 42.3 m-kg
D205-564-011 (205/210/212/214/412)	23.0 lb 10.45 kg	0.0 in 0.0 m	0.0 lb-in 0.0 m-kg	172.0 in 4.37 m	3956.0 in-lb 45.7 m-kg

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
DSI-9328-011 (204)	15.0 lb 6.8 kg	0.0 in 0.0 m	0.0 lb-in 0.0 m-kg	146.5 in 3.72 m	2198 in-lb 25.3 m-kg
DSI-9328-011 (205/210/212/214/412)	15.0 lb 6.8 kg	0.0 in 0.0 m	0.0 lb-in 0.0 m-kg	159.0 in 4.04 m	2385 in-lb 27.5 m-kg

5.0 PARTS LIST

Qty	Part Number	Description
X	D205-564-011	BEARPAW INSTALLATION
8	D2182B055	RUBBER CUSHION
20	D2274	RADIUS BLOCK
2	D2521	BEARPAW
20	D2529	WASHER
8	D2947	CLAMP
4	D3544-041	CLAMP
8	AN4-13A	BOLT
16	AN4-15A	BOLT
4	AN4-17A*	BOLT
20	AN960JD416	WASHERS
20	MS21042L4	NUT (OR MS21042-4)

*Note: AN4-17A bolts are for installations on Bell Float Skid tubes

Qty	Part Number	Description
X	DSI-9328-011	RUN-ON LANDING WEARPLATE KIT
2	D3511-041	WEARPLATE
16	AN4-17A	BOLT
4	AN4-11A	BOLT
4	AN970-4	WASHER
16	MS21042L4	NUT (OR MS21042-4)